



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3011
Job Sheet 170447



Part No: 646.3011

Job Qty: 10 ea

Part Name: RH Half



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/24/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV N/C SHEETS 2,6,7 IPP REV:A NEW ISSUE 13/01/14 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/24/18	0.00	0.00	Start Up Machining-1		S.C. 18/03/03
100	Bandsaw	10 pcs		1/24/18	0.00	0.11	Bandsaw1		S.C. 18/03/03
110	CNC Vertical Machining	10 pcs		1/24/18	0.18	8.00	HAAS1-1		S.C. 18/03/03
120	QC	10 pcs		1/24/18	0.00	0.00	QC1		S.C. 18/03/03
130	QC	10 pcs		1/24/18	0.00	0.00	QC8 Machining-1		J.C. 18-03-05
140	Outsource	10 pcs		1/24/18	0.00	0.00	Outsource4		APR 05/15
150	Packaging	10 pcs		1/24/18	0.00	0.00	Packaging2		APR 05/15
155	QC	10 pcs		1/24/18	0.00	0.00	QC5	66.6	MAY 25 2018
180	Packaging	10 pcs		1/24/18	0.00	0.00	Packaging3-1		JUN 01 2018
190	QC21-SA	10 Ea		1/24/18	0.00	0.00	QC21		JUN 01 2018

Part Op 100 - Cut Blank at 9.700"

Descriptions: 110 - 1-Machine per folio FB158

120 - Inspect on CMM as per folio CMMA029.

140 - Issue P/O to ATG : P6039246

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

MAR 08 2018

5044632 = 8.09 pi

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6B6.000X0.250	8	0	0	0

50477435
50477438

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐																																																	
Date : _____	Step #: _____	MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																																																	
Description Work Order Deviation																																																			
Root Cause <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">Environment ☐</td> <td style="width: 15%;">No Re-verification ☐</td> <td style="width: 15%;">Pressure/Forced ☐</td> <td style="width: 15%;"></td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td></td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td></td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td></td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td></td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td></td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td></td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td></td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td></td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td></td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td>OTHER : ☐</td> <td></td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐		Design ☐	Operator ☐	Bending ☐		Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐		Equip/Tooling ☐	Supplier ☐	Cracks ☐		Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐		Material ☐	Use for Testing ☐	Cuffs ☐		Internal Transport ☐	Poor Information ☐	Crushing ☐		Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐		LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐		Substation ☐	Process Improvement ☐	Marks/Chatter ☐		Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐	OTHER : ☐	
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Container No: S047438 Part: 646.3011 Job No: 170447 Serial No/Batch: S047438 Revision: Inspector:  DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																			

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	RH Half	0.250inches $\pm$ 0.005	0.255 0.245	0.25	
2	RH Half	0.109inches $\pm$ 0.005	0.114 0.104	0.114	
3	RH Half	0.200inches $\pm$ 0.005	0.205 0.195	0.195	
4	RH Half	0.050inches $\pm$ 0.005	0.055 0.045	0.046	
5	RH Half	9.536inches $\pm$ 0.005	9.541 9.531	9.536	
6	RH Half	0.209inches + 0.005 - 0.001	0.214 0.208	0.210	Diameter
7	RH Half	0.177inches + 0.005 - 0.001	0.182 0.176	0.182	Diameter
8	RH Half	0.250inches $\pm$ 0.005	0.255 0.245	0.255	
9	RH Half	0.625inches $\pm$ 0.005	0.630 0.620	0.625	

Plex 1/16/18 1:25 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039246

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039246
PO Date: 3/8/18
Due Date: 3/16/18
Purchase Order Revision:
Revision Date: 3/20/18
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com
Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED

MAR 20 2018

Phone: 613-652-0200

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171648	D5574-1	Blade Housing, Cable Cutter Issue P/O to ATG : Black Anodize & Prime as per Dwg. D5574 Certification of Conformity is required.	Firmed	4/2/18	3 pcs	0 pcs 3x	3 pcs	\$11.87/pcs	\$35.61
2	172352	D5575-3	Break Away Tip, Lower Deflector Issue P/O to ATG : Black Anodize & Prime as per Dwg. D5575-3 Certification of Conformity is required.	Firmed	4/2/18	2 pcs	0 pcs 2x	2 pcs	\$10.12/pcs	\$20.24
3	170170	647.7810	Bracket A Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	4/2/18	4 pcs	0 pcs x4	4 pcs	\$16.12/pcs	\$64.48
4	170171	647.7811	Bracket B Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	4/2/18	4 pcs	0 pcs x4	4 pcs	\$16.12/pcs	\$64.48
5	169393-A	647.7912	Clip ISSUE P/O: Hard Anodize, Color Black and Prime As Per Dwg. 647.7900	Firmed	4/2/18	12 pcs	0 pcs 12x	12 pcs	\$11.22/pcs	\$134.64

3/20/2018

PURCHASE ORDER

Items										Unit Price (CAD)	Extended Price
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance			
6	170446	646.3010	LH Half Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3000	Firmed	4/2/18	10 pcs	0 pcs	10 pcs		\$11.87/pcs	\$118.70
7	170447	646.3011	RH Half Issue P/O to ATG : Hard Black Anodize, Color Black and Prime as Per Dwg 646.3000	Firmed	4/2/18	10 pcs	0 pcs	10 pcs		\$11.87/pcs	\$118.70
		171979		Firmed	4/2/18	16 pcs	0 pcs	16 pcs		\$11.87/pcs	\$189.92
			Sub Total:			26	0	26			\$308.62
8	171847	C45-8-5	Solenoid Cover -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	3/23/18	20 pcs	0 pcs	20 pcs		\$5.37/pcs	\$107.40
9	172471	RBE350A94-3701-00	Main Rotor Rigging Tool -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As per Dwg RBE350A94-3701-00 Rev. 2A -Certificate of Conformity is required	Firmed	3/23/18	6 pcs	0 pcs	6 pcs		\$4.77/pcs	\$28.62
10	173384	SWA10A-700A	Wire Clamp -Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed	3/23/18	28 pcs	0 pcs	28 pcs		\$7.37/pcs	\$206.36
11	172447	RBE350A94-2708-01-01	Slide -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As per Dwg RBE350A94-2708-01-01 Rev. G -Certificate of Conformity is required	Firmed	3/23/18	4 pcs	0 pcs	4 pcs		\$4.77/pcs	\$19.08

DAS
11
9-89

18/03/23

18/03/23

18/03/23



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915236

Date: 25-May-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diar Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.3011 RH Half Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22693	Rev: NC PO: PO039246 Line: 7	DAS 11 9-89 MAY 25 2018
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>25/5/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.